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D2282-5**Job Sheet 202163****Part No:** D2282-5**Job Qty:** 50 pcs**Part Name:** Tube**Part Weight:** 0 lbs**Status:** New**Priority:** Medium**Job Created:** 10/21/19**Job Tracking No:****Due Date:** 12/5/19**Created By:** Marie Lajeunesse**Type:** SOLD**Description:**

Note: DWG REV E IPP Rev:A Removed from 9 Digit 05-12-02 JLM IPPRev:B Now on Doosan Lathe 08-06-05 JLM
Verified By:EC

Ship Via:**Bill of Materials****Job Routing**

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Doosan - 1	50 pcs	12/5/19	12/5/19	0.03	7.77	Doosan - 1		
120	QC 8	50 pcs	12/5/19	12/5/19	0.00	0.00	QC 8 - 12		
							QC 8 - 14		
							QC 8 - 17		
							QC 8 - 20		
							QC 8 - 25		
							QC 8 - 3		
							QC 8 - 32		
							QC 8 - 33		
							QC 8 - 35		
							QC 8 - 39		
							QC 8 - 4		
							QC 8 - 44		
							QC 8 - 45		
							QC 8 - 49		
							QC 8 - 58		
							QC 8 - 8		
							QC 8 - 9		
							QC 8 - 68		
							QC 8 - 67		
							QC 8 - 1 (A)		
							QC 8 - 47		
							QC 8 - 40		
							QC 8 - 52		
							QC 8 - 23		
							QC 8 - 57		
							QC 8 - 76		
							QC 8 - 61		
130	Packaging 3-1 - Stock - B4B	50 pcs	12/5/19	12/5/19	0.00	0.00	Packaging 3 - 1 - B4B		
							Packaging 3 - 2 - B4B		



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Container No: S235888**Part:** D2282-5**Job No:** 202163**Serial No/Batch:** S235888**Revision:****Inspector:****Exp Date:****Instructions:** Various STC's**Date:** 11/29/19

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					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	
					Packaging 3 - 6 - B4B	
					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	PC 11/20/19
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
					Packaging 3 - 36 - B4B	
140 QC 21 - SA	50 pcs	12/5/19	0.00 0.00	QC 21 - SA - 21	DAS	
				QC 21 - SA - 70	21	
				QC 21 - SA - 53	53	DEC 2 2019

Part Op 100 - (Doosan Lathe) 1-Turn as per Dwg D2282 and Folio FA189
 Descriptions: 120 - (QC8- Inspect parts - second check)
 130 - (Identify as per dwg & Stock Location: _____) *****STOCK IN LARGE FAB*****
 140 - (QC5- Inspect part completeness to step on W/O)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M304R0.750	304 SS Roundbar .750	9.0030 ft (.18006 ea)	100-Doosan - 1	5232320

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Doosan - 1	M304R0.750	9	25	0

1.095 T .048

Part Specifications					
Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Handle Tube	2.170Inches $\pm$ 0.030	2.200 2.140		
2	Handle Tube	0.063Inches $\pm$ 0.010	0.073 0.053	Radius	
3	Handle Tube	0.063Inches $\pm$ 0.010	0.073 0.053		
4	Handle Tube	0.125Inches $\pm$ 0.010	0.135 0.115		
5	Handle Tube	0.090Inches $\pm$ 0.010	0.100 0.080		
6	Handle Tube	45.000Degrees $\pm$ 0.000	45.000 45.000	Angle	
7	Handle Tube	0.350Inches + 0.010 - 0.000	0.360 0.350	Radius	
8	Handle Tube	0.158Inches $\pm$ 0.010	0.168 0.148		
9	Handle Tube	0.386Inches + 0.005 - 0.000	0.391 0.386	Diameter	
10	Handle Tube	0.700Inches $\pm$ 0.010	0.710 0.690	Diameter	

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Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					